

Ship TODAY

Work Order ID 70752

Tuesday, June 14, 2011 10:42:30 AM



Page 1

Item ID: D350-567-031B

Accept



Setup Start



Revision ID:

Stop



Item Name: Interior Floor Window (Sliding Door Compatible)

Start Date: 6/14/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/14/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool # Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

N/A

Rev D D31 Q561 REV.A 11.06.14

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy blue file and create labels per PPP D350-567-031B chg001

8/16/14

For CL 11-6-14

110

0.00



Packaging

Packaging

Packaging

Memo

0.00

Pick Packing Kit

11/6/14 SP

120

0.00



QC

Quality Control

QC4- 100% Inspect kits for completeness

Memo

0.00

8/16/14

70

**Work Order ID 70752**

Tuesday, June 14, 2011 10:42:30 AM



Page 2

Item ID: D350-567-031B

Accept



Setup Start



Revision ID:

Stop



Item Name: Interior Floor Window (Sliding Door Compatible)

Start Date: 6/14/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/14/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Packaging	Packaging	0.00							
Packaging	Memo Identify and pack for shipping as per PPP D350-567-031B Location: PPP Rev: <i>Draft</i>	0.00							
140  QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.00							

11/6/14

11/6/14

MF  
11-06-14

# Picklist Print

Tuesday, June 14, 2011 10:42:27 AM

Page 1

Work Order ID: 70752

Parent Item: D350-567-031B

Parent Item Name: Interior Floor Window (Sliding Door Compatible)







Start Date: 6/14/2011


Required Date: 6/14/2011


Start Qty: 1.00


Required Qty: 1.00


Comments: IPP REV:A NEW ISSUE 11-06-13 JLM VERIFIED BY:


Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2463-0450  Neoprene Seal		Manufactured	No			110	Each	9.0000	1	1			
<div> <div>↳ measured Sunday @ 4:50<sup>pm</sup></div> <div> <div>Location</div> <div>ST402</div> <div>63486</div> </div> <div> <div>Loc Qty</div> <div>9</div> <div>9</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div> </div>													
D3210-1B  Doubler		Manufactured	No			110	Each	0.0000	1	1			
D3211-1B  Bracket		Manufactured	No			110	Each	0.0000	1	1			
D3212-1B  Floor Window		Manufactured	No			110	Each	0.0000	1	1			
D3213-041B  Door Assembly		Manufactured	No			110	Each	0.0000	1	1			
AN526C632R12  Screw		Purchased	No			110	Each	126.0000	8	8			
<div> <div></div> <div> <div>Location</div> <div>ST326</div> <div></div> </div> <div> <div>Loc Qty</div> <div>126</div> <div>2</div> <div>24</div> <div>100</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> <div></div> </div> </div>													


 B66934 SP

 B70437 SP

 B70430 SP

 B70431 SP

 70432 SP

 116114 SP

8

# Picklist Print

Tuesday, June 14, 2011 10:42:27 AM

Page 2

Work Order ID: 70752

Parent Item: D350-567-031B

Parent Item Name: Interior Floor Window (Sliding Door Compatible)

Start Date: 6/14/2011

Required Date: 6/14/2011

Start Qty: 1.00

Required Qty: 1.00

AN960JD6 NAS1149DN632J Purchased No

110 Each 50.0000



Washer



8 8  
M116978

Location

Loc Qty

Loc Code

ST347

50

104537

50

MS21042L06

Purchased No

110 Each 212.0000



Nut



8  
sf

Location

Loc Qty

Loc Code

ST300

212

117442

62

117601

150

MS20470AD4-5

Purchased No

110 Each 864.0000



Rivet, Universal Head



40  
sf

Location

Loc Qty

Loc Code

ST319

864

116893

864

MS20470AD4-6

Purchased No

110 Each 3,609.000



Rivet, Universal Head



70  
90  
116/14sf

Location

Loc Qty

Loc Code

ST319

3609

117395

2094

117887

1515

90

Tuesday, June 14, 2011 10:42:28 AM

Shop Packet Print

Page 2

# Picklist Print

Tuesday, June 14, 2011 10:42:28 AM

Page 3

Work Order ID: 70752



Parent Item: D350-567-031B



Parent Item Name: Interior Floor Window (Sliding Door Compatible)

Start Date: 6/14/2011

Required Date: 6/14/2011

Start Qty: 1.00

Required Qty: 1.00

MS20470AD4-7

Purchased

No

110

Each

3,102.000

20

20



Rivet, Universal Head



11/6/14

Location

Loc Qty

Loc Code

ST320

3102

116081

502

117423

1300

117887

1300

20

# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-567 REV. D  
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-567 REV. 1  
REF. TCCA STC: SH92-18  
REF. FAA STC: SH989NE AND SH990NE  
REF. EASA STC: EASA.IM.R.S.01560 AND EASA.IM.R.S.01561

## 1.0 PURPOSE


This service instruction is intended for customers wishing to upgrade their existing cabin floor window from D350-567-011 Kit with a D350-567-031 Floor Window Kit. Since the two kits do not share the same rivet patterns, the D350-567-031B Kit from this service instruction replaces D350-567-031 Kit to facilitate installation without having to perform extensive rework/repair of the aircraft floor prior to installation.



## 2.0 INSTALLATION CHANGE

**Note:** In reference with Installation Instructions D350-567, make the following substitutions:

- D3210-1B replaces D3210-1;
- D3211-1B replaces D3211-1;
- D3212-1B replaces D3212-1;
- D3213-041B replaces D3213-041.

- 2.1 Perform Steps 3.4.1 and 3.4.2 of Installation Instructions D350-567 as required.
- 2.2 Locate the D3210-1B per Figure 1 of this service instruction.
- 2.3 Determine whether to trim D3210-1B or shim the sliding door rail per Step 3.4.8 of D350-567 as required to ensure compatibility with Eurocopter Sliding Door if installed on aircraft.
- 2.4 Enlarge the viewing hole in the aircraft floor by using D3210-1B as template.
- 2.5 Transfer drill  $\varnothing 0.128$ " holes from the aircraft floor to D3210-1B Doubler, D3211-1B Bracket, and D3212-1B Window. Drill additional holes as required through D3210-1B and aircraft floor. Ensure minimum pitch and edge distance as indicated.
- 2.6 Enlarge as required qty(4)  $\varnothing 0.128$ " holes to  $\varnothing 0.141$ " and drill qty(4)  $\varnothing 0.141$ " as shown in Figure 1 of this service instruction.
- 2.7 Locate D3213-041B and transfer drill qty(12)  $\varnothing 0.128$ " and qty(3)  $\varnothing 0.141$ " holes from the D3210-1B Doubler/aircraft floor to the blank hinge blade of D3213-041B.
- 2.8 Complete installation in accordance with Section 3.4 of Installation Instructions D350-567.

CANADA	
DEPARTMENT OF TRANSPORT	
AIRCRAFT CERTIFICATION	
BRANCH	
DAO # 01-O-01	
APPROVED	
BY:	
	D. SHEPHERD (DE # 02)
DATE:	11.06.10
CERT. NO.:	SH92-18
ISSUE NO.:	6

A	NEW ISSUE	MB	11.06.07
REV.		DESCRIPTION	BY DATE
DESIGN	B	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	CP	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9561	SHEET 1 OF 4
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### 3.0 PARTS LIST


Qty -031B	Part Number	Description
X	D350-567-031B	INTERIOR FLOOR WINDOW KIT (SLIDING DOOR COMPATABLE)
1	D2463-0450	NEOPRENE SEAL
1	D3210-1B	DOUBLER, BLANK
1	D3211-1B	BRACKET, BLANK
1	D3212-1B	FLOOR WINDOW, BLANK
1	D3213-041B	DOOR ASSEMBLY, W/BLANK HINGE BLADE
8	AN526C632R12	SCREW (OR AN526C632-12, OR MS51957-32)
8	AN960JD6	WASHER
8	MS21042L06	NUT (OR MS21042-06)
40	MS20470AD4-5	RIVET
90	MS20470AD4-6	RIVET
20	MS20470AD4-7	RIVET





### 4.0 WEIGHT AND BALANCE

There is a negligible weight change associated with this modification. If upgrading from D350-567-011 to D350-567-117, refer to the weight and balance information for D350-567-117 of Installation Instructions D350-567.

### 5.0 MAINTENANCE AND CONTINUED AIRWORTHINESS

Maintenance and continued airworthiness instructions for D350-567-031B is the same as for D350-567-031. Refer to ICA-D350-567.

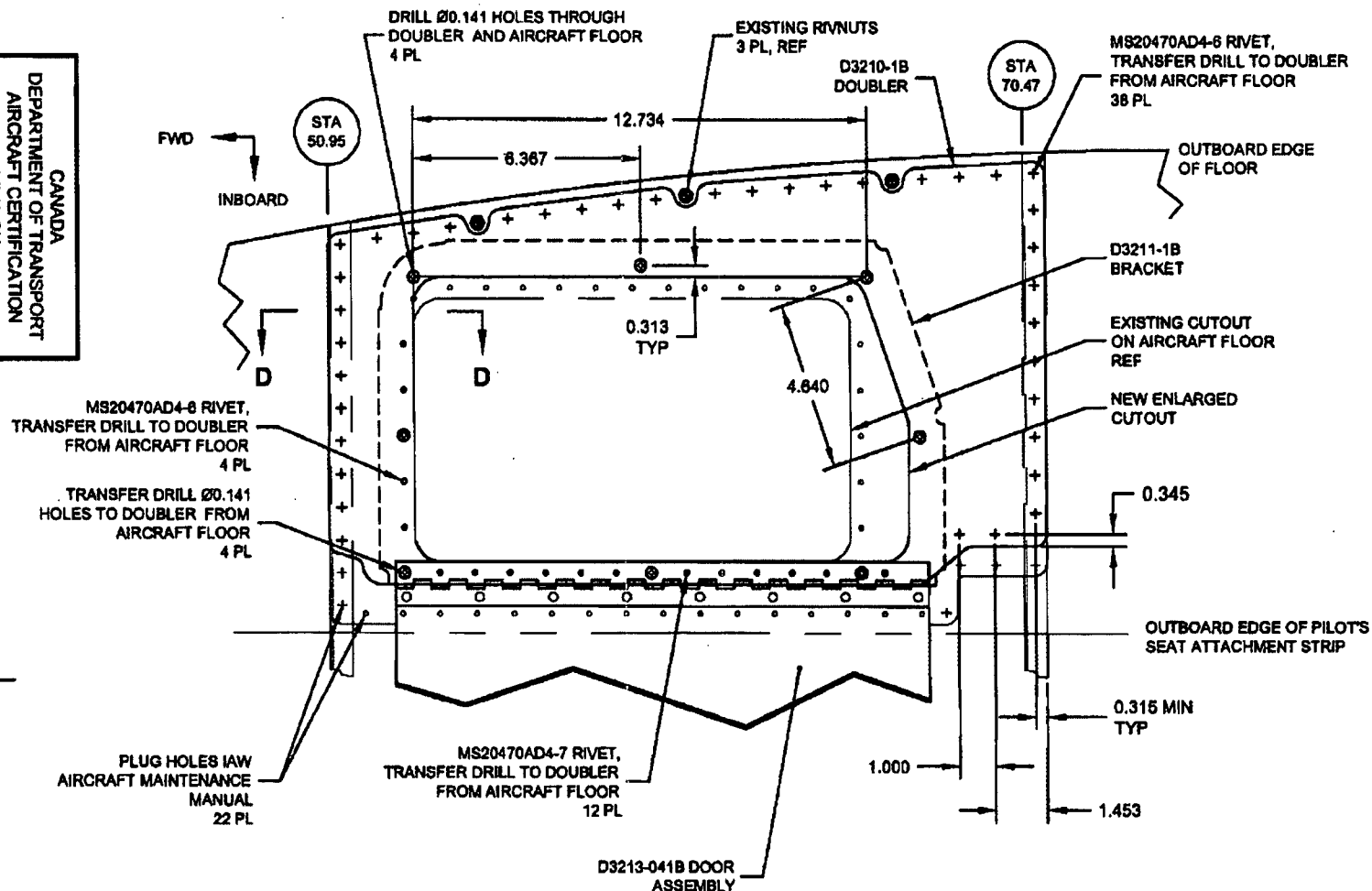
CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
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BY:	
	D. SHEPHERD (DE # 02)
DATE:	11.06.10
CERT. NO.:	SH92-18
ISSUE NO.:	6

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AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED  
BY: *[Signature]*  
D. SHEPHERD (DE # 02)

DATE: 11.06.10  
CERT. NO.: SH9248  
ISSUE NO.: 6



**FIGURE 1: D350-567-031B KIT OVERVIEW  
AND HOLE TRANSFER DRILLING GUIDELINE**  
(SLIDING DOOR MOD NOT SHOWN)

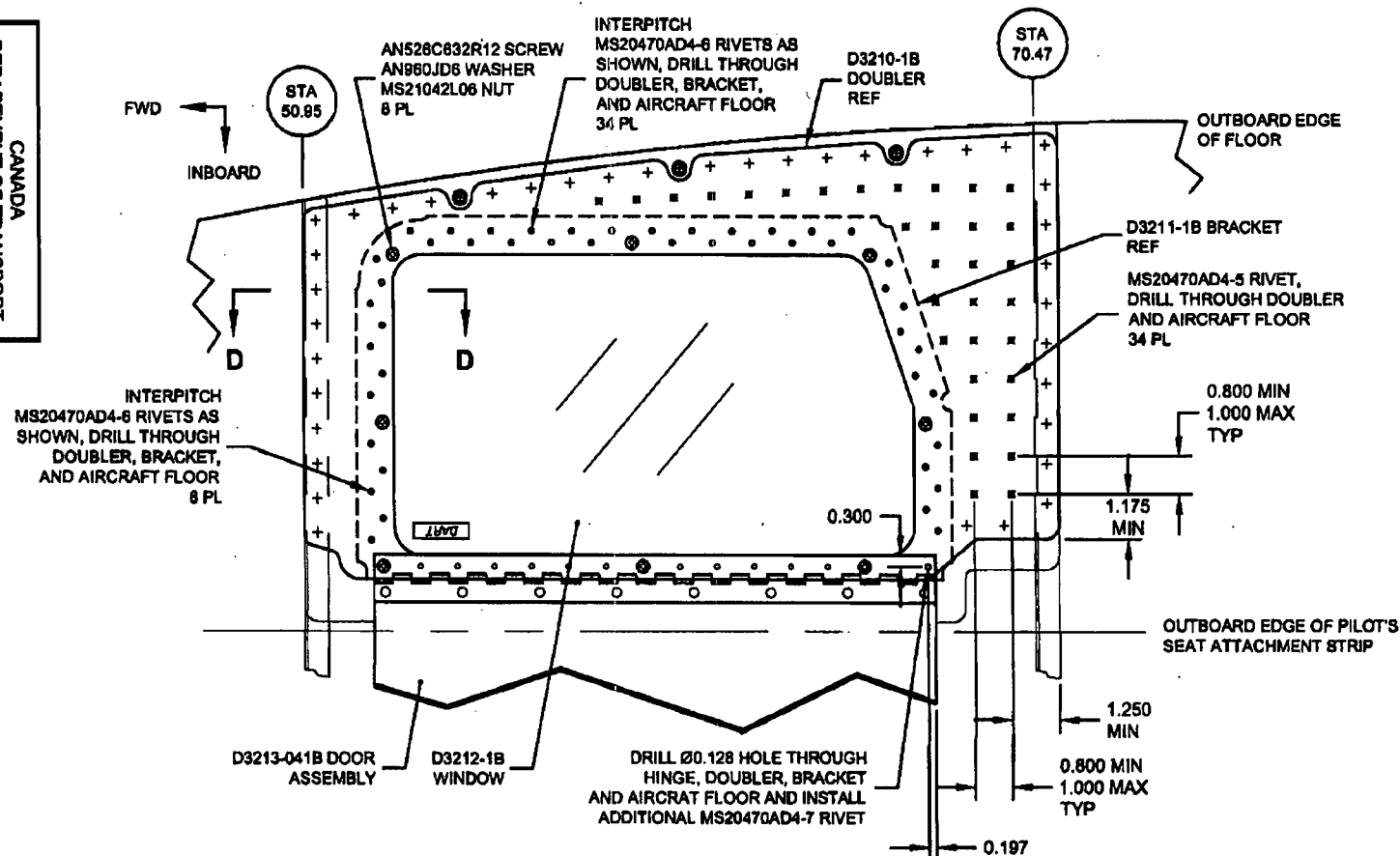
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AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

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BY: D. SHEPHERD (DE # 02)

DATE: 11.06.10  
CERT. NO.: SH92-18  
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**FIGURE 2: TYPICAL PITCHES FOR  
ADDITIONAL REQUIRED RIVETS  
(SLIDING DOOR MOD NOT SHOWN)**

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CHECKED		
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APPROVED		
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REFERENCE ONLY

### 3.0 PARTS LIST

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1	D3211-1B	BRACKET, BLANK
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1	D3213-041B	DOOR ASSEMBLY, W/BLANK HINGE BLADE
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8	AN980JD6	WASHER
8	MS21042L06	NUT (OR MS21042-06)
40	MS20470AD4-5	RIVET
90	MS20470AD4-6	RIVET
20	MS20470AD4-7	RIVET

### 4.0 WEIGHT AND BALANCE

There is a negligible weight change associated with this modification. If upgrading from D350-567-011 to D350-567-117, refer to the weight and balance information for D350-567-117 of Installation Instructions D350-567.

### 5.0 MAINTENANCE AND CONTINUED AIRWORTHINESS

Maintenance and continued airworthiness instructions for D350-567-031B is the same as for D350-567-031. Refer to ICA-D350-567.

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED  
BY: *[Signature]*  
D. SHEPHERD (DE # 02)

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ISSUE NO.: 6

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9561	SHEET 2 OF 4
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